



Dart Aerospace Ltd.
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647.1702
Job Sheet 203254



Part No: 647.1702

Job Qty: 4 pcs

Part Name: Skid Deflector Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/13/19

Job Tracking No:

Due Date: 12/10/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E IPP REV:A NEW ISSUE 13.07.17 JLM VERIFIED BY:DD IPP REV:B 14.09.26 AS PER DWG C1 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Small Fab - 1	4 pcs	12/10/19		0.00	1.64	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		DAS
							Small Fab - 6		41 DEC 19 2019
							Small Fab - 7		8-89
							Small Fab - 8		
							Small Fab - 9		
130	QC 5	4 pcs	12/10/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		DAS
210	Packaging 3-1 - Stock - B4B	4 pcs	12/10/19		0.00	0.00	QC 5 - 61		DEC 20 2019 40
							QC 5 - 81		8-89
							Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		

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Container No: S242637



Part: 647.1702
Job No: 203254
Serial No/Batch: S242637

Revision:
Inspector:
Exp Date:
Instructions: Various STC's Date: 12/23/19

Packaging 3 - 3 - B4B	
Packaging 3 - 4 - B4B	
Packaging 3 - 5 - B4B	
Packaging 3 - 6 - B4B	
Packaging 3 - 7 - B4B	
Packaging 3 - 8 - B4B	
Packaging 3 - 9 - B4B	
Packaging 3 - 10 - B4B	
Packaging 3 - 11 - B4B	
Packaging 3 - 12 - B4B	
Packaging 3 - 13 - B4B	
Packaging 3 - 14 - B4B	
Packaging 3 - 15 - B4B	
Packaging 3 - 16 - B4B	
Packaging 3 - 17 - B4B	
Packaging 3 - 18 - B4B	
Packaging 3 - 19 - B4B	
Packaging 3 - 20 - B4B	
Packaging 3 - 21 - B4B	
Packaging 3 - 22 - B4B	
Packaging 3 - 23 - B4B	PC CCR033
Packaging 3 - 24 - B4B	
Packaging 3 - 25 - B4B	
Packaging 3 - 26 - B4B	
Packaging 3 - 27 - B4B	
Packaging 3 - 28 - B4B	
Packaging 3 - 29 - B4B	
Packaging 3 - 30 - B4B	
Packaging 3 - 31 - B4B	
Packaging 3 - 32 - B4B	
Packaging 3 - 33 - B4B	
Packaging 3 - 34 - B4B	
Packaging 3 - 35 - B4B	
Packaging 3 - 36 - B4B	
QC 21 - SA - 21	DAS
QC 21 - SA - 70	21
QC 21 - SA - 53	2.50

220 QC 21 - SA 4 pcs 12/10/19 0.00 0.00

Part Op 120 - 1- Assemble item 4,6,7 and 8 as per dwg. 2- Clamp item 1 and 2 to item 3. Transfer drill holes as per dwg see note
Descriptions: 6. Use clecos. 3- Disassemble parts 4- Deburr 5- Touch up expose aluminum with alodine *** **TOUCH UP RIVET WITH
PRIMER *** PRIMER BATCH: *** 6- Re-assemble as per dwg
130 - (QC5- Inspect part completeness to step on W/O)
210 - (Identify as per dwg & Stock Location: _____), ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND
REV***
220 - (QC21- Final Inspection - Work Order Release)

DEC 20 7:10

Part / Item	Component Name	Quantity	Operation	Container
647.1712	Gusset	4 pcs (1 ea)	120-Small Fab - 1	
647.1713	Spacer	4 pcs (1 ea)	120-Small Fab - 1	5230020
647.1714	Plate	4 pcs (1 ea)	120-Small Fab - 1	5207001
647.1715	Plate	4 pcs (1 ea)	120-Small Fab - 1	5105696
CR3213-4-4	Rivet, Cherry	88 Ea (22 ea) +8 scrap	120-Small Fab - 1	5229992 9101096
MS21042L3	Nut	4 Ea (1 ea)	120-Small Fab - 1	5235463
MS27039-1-14	Screw	4 Ea (1 ea)	120-Small Fab - 1	5218152(3) 5204283(1)
NAS1149F0332P	Washer (AN960-10L)	4 Ea (1 ea)	120-Small Fab - 1	5162000
		8 Ea (2 ea)	120-Small Fab - 1	5228841

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
120-Small Fab - 1	647.1712	4	24	0
	647.1713	4	10	0
	647.1714	4	11	0
	647.1715	4	22	0
	CR3213-4-4	88	282	0
	MS21042L3	4	2,420	0
	MS27039-1-14	4	56	0
	NAS1149F0332P	8	4,820	0
Part Specifications				
Specifications could not be found.				

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Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)			
Description Work Order Deviation		Disposition					
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐				Completed By Lead hand / Supervisor QC / QA Coordinator	
Other/Details:							